

Date: Thursday, 4/12/2007 8:21:30 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEB ASSEMBLY
Job Number	31651			
Estimate Number	10194			
P.O. Number	N/A		Part Number	D2174041
This Issue	4/12/2007	S.O. No. N/A	Drawing Number	D2174 REV E
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	E
Previous Run	30808		Material	N/A
Written By			Due Date	4/30/2007
Checked & Approved By		07.04.12	Qty:	40
Comment	Est: D 04.06.10	Reformat; Changed Step 2	KJ/JLM	Urn: Each
		Est Rev:E	As per Rev E	33
			06-11-22	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D21741	Web	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 40.0000 Each(s)	
	Web		
	Qty Part Number	Description Batch	
	1 D2174-1	Web B31689 x 33mx -	
2.0	D21751	Angle LH	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 40.0000 Each(s)	
	Angle LH		
	Qty Part Number	Description Batch	
	1 D2175-1	Angle B30871 x 4mx, B31690 x 39mx -	
3.0	D21752	Angle RH	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 40.0000 Each(s)	
	Angle RH		
	Qty Part Number	Description Batch	
	1 D2175-2	Angle B31441 x 18mx, B31691 x 15mx -	
4.0	MS20470AD46	Rivet, Universal Head	
	Comment: Qty.: 19.0000 Each(s)/Unit	Total : 760.0000 Each(s)	
	Rivet, Universal Head		
	Qty Part Number	Description Batch	
	19 MS20470AD4-6	Rivet m103691 -	MF 07-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:30 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEB ASSEMBLY
Job Number: 31651		Part Number: D2174041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D2174-041 2- Identify as D2174-041		MF 07-05-28 (33)
6.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		SB 07/05/30 (33)
7.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		BR/Fel. 07-05-31 (33)
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		MF 07-06-05
9.0	AN526C832R14 	Screw
Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) Screw Batch: M9216		
10.0	AN960JD8 	Washer
Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) Washer Batch: M103585 125		(35) M104093
11.0	MS21042L08 	Nut
Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) Nut Batch: M104118		7/21, S9
12.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Install nuts & bolts loosely as per Dwg D2274		MF 07-06-05 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/05
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 31651

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/05 (33)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 (33)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN
RF

DRAWN BY
CE

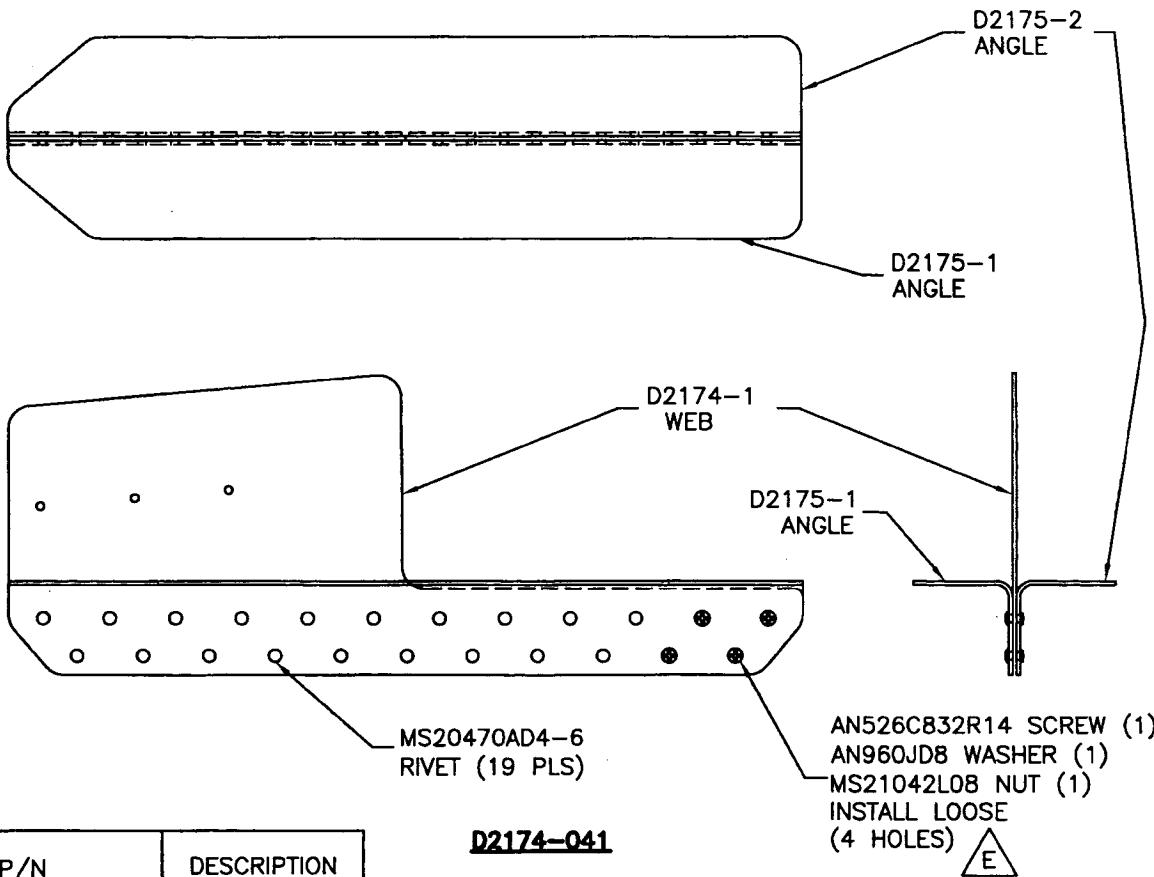
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. E

DATE	DRAWN BY	APPROVED	REV. E
06.09.25	<i>PH</i>	<i>CH</i>	
			DRAWING NO.
			D2174
			SCALE
			1:3

A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN
E	06.09.25	INC 4 HOLES TO ϕ 0.172; CHG HARDWARE

RELEASED
06.10.13
11

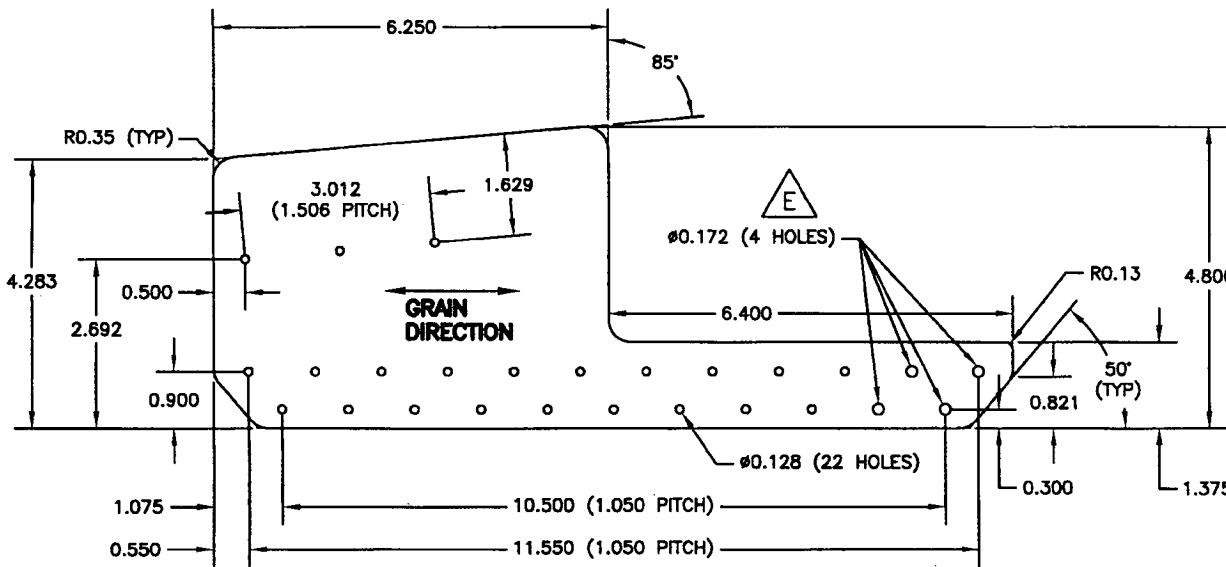
**D2174-041**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 365

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

ALL DIMENSION ARE IN INCHES

NO. 3165
 WORK ORDER
 ENGINEERING
 CONTROLLED COPY
 DRAFTED TO AMENDMENT
 WITHOUT NOTICE
 REV. E
 SHEET 2 OF 2
 SCALE 1:3

RELEASED
 06/16/03
 4

DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PHT	TH	D2174
DATE		TITLE
06.09.25		WEB